

Date: Tuesday, 04/11/2008 2:03:22 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SQUARE TUBE
Job Number	: 43199 - 1	Part Number	: PB6743001207
Estimate Number	: 13420	Drawing Number	: B6743001 P.5/ P.16
P.O. Number	:	Project Number	: N/A
This Issue	: 04/11/2008	Drawing Revision	: B1
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 11/11/2008
Previous Run	: 42603	Qty:	
Written By	:	Um:	
Checked & Approved By	: MF 08-11-04	Eac	
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

SP Lit
6
X Um: Eac

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TS1000W120	6061T6 SQ TUBE 1.00 x 1.00 X .120w ✓
		Comment: Qty.: 1.9469 f(s)/Unit Total : 9.7346 f(s) 6061T6 SQ TUBE 1.00X.120 batch: M109928
		SND 08-11-20
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1
		1- cut to length as per dwg 2- make a 0.090" chamfer on both ends of tube 3- deburr
3.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE 1- drill holes as per dwg 2- make a 0.090" chamfer (100 degree) on both side of the 4 holes 3- deburr
5.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 43199

Part Number: PB6743001207

Number:



Seq. #:

Machine Or Operation:

Description :

6.0 PB6743001225

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)
 Bushing ~~D 40272 - 8~~ ~~B24005 - 16~~
 batch: ~~B40272 - 8~~ ~~B24005 - 16~~

PCL 08.11.25

7.0 PB6743001223

Square Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
 Square Cap ~~B42604 B42604 - 6~~
 batch: ~~B42604 B42604 - 6~~

PCL 08.11.25

8.0 LARGE FAB 1

LARGE FABRICATION RESOURCE



(x6)

Comment: LARGE FABRICATION RESOURCE 1
 1- Weld assembly as per dwg

PCL 08.11.25

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- grind weld flush
 2- deburr

SAD 09-11-26
 PCL 08.11.26

10.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8 08/11/26

(x6)

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/26 (x6)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



(6x)

Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: 438

G/11/26

SP

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26 JJ

MF 08-11-26

RELEASED
06-01-20

-07 FWD BLADE FOLD ASSEMBLY WELDMENT (COMMERCIAL VERSION)
SCALE 0.250

-05 FWD BLADE FOLD ASSEMBLY WELDMENT (CANADIAN VERSION)
(SAME, EXCEPT AS SHOWN)

DETAIL F
SCALE 0.500

PREMIER AVIATION, INC.
200 Aviation Parkway, Grand Prairie, Texas 75002
D105UVB B67-43001

RELEASER
06-01-20

SEE DETAIL F

Mo 43199

Y3/99

-07 FWD BLADE FOLD ASSEMBLY WELDMENT (SHOWN)

(COMMERCIAL VERSION)
SCALE D-260

SCALE 6.250

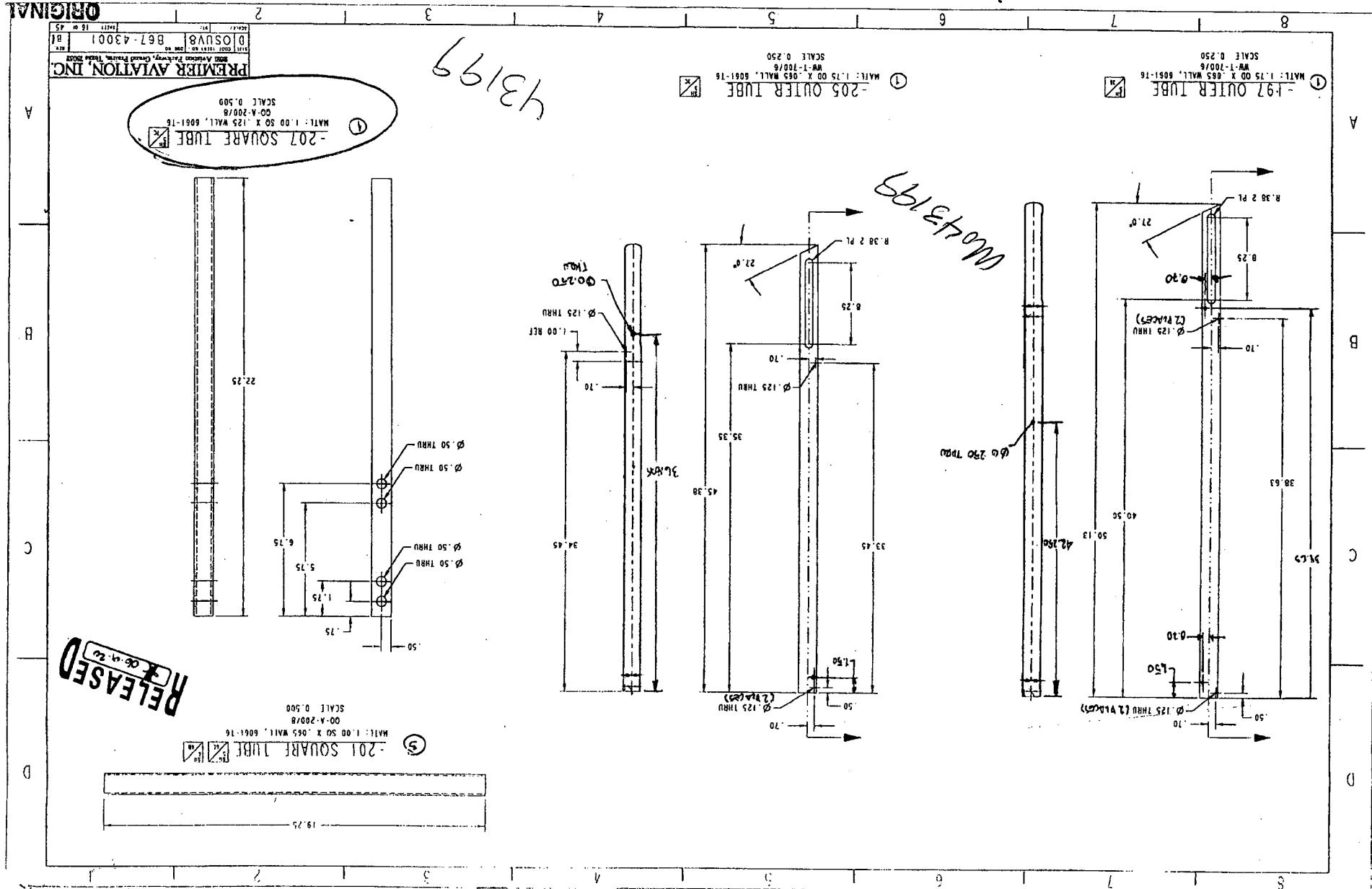
-05 FWD BLADE FOLD ASSEMBLY WELDMENT (SAME, EXCEPT AS SHOWN
(CANADIAN VERSION))

THE OLD ASSOCIATION (CANADIAN VERSION)

PREMIER AVIATION, INC.
2001 Aviation Parkway, Grand Prairie, Texas 75052

DATE	CODE	STAN. NO.	OPN. NO.	
D	OSUV8	B67-43001		81
SCALE:	(1:1)		14001	5. M. 45

ORIGINAL



AEROSPACE LTD

Work Order:

43199

Description: Square Tube

Part Number: PB67430-1207

Inspection Dwg:

Rev: B1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

X First Article

X

X | Prototype

Measured by:

10

Audited by:

Audi

Prototype Approval:

八

Date

08/11/24

Data:

06 / 4 / 24

Date:

6

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	